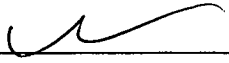


Date: Monday, 10/2/2006 11:11:43 AM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHORT STEP ASSEMBLY
Job Number : 28760	
Estimate Number : 11999	
P.O. Number : N/A	Part Number : D350591122
This Issue : 10/2/2006	Drawing Number : D2351 REV E
S.O. No. : N/A	Project Number : N/A
Prsht Rev. : NC	Drawing Revision : E
First Issue : N/A	Material : N/A
Type : LARGE FAB ASSY	Due Date : 10/9/2006
Previous Run : 28760	Qty: 4 Um: Each
Written By : 	
Checked & Approved By : _____	
Comment : Est Rev:E 02.10.21 Re-format; Incorporated D2351-041 IPP K J/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-122 CHG003

KS 06.10.02

(1)

2.0	D2244116	Step Extrusion
-----	----------	----------------



Comment: Qty.: 0.5000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
0.5 D2244-128 Extrusion	323404	

FE

06-10-02

4

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244-128 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G

FE 06.10.02 4

2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.

FE 06.10.02 4

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

D 06-10-02

(16)

5.0	BENDING	BENDING MACHINE
-----	---------	-----------------



Comment: BENDING MACHINE

Bend as per dwg

DP 6-12-1

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/2/2006 11:11:43 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY

Job Number: 28760

Part Number: D350591122

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

MOG/12/01 (4)

7.0	D28502	End Bracket
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2850-2	End Bracket	<i>39907 = 2 B10952 = 2 P.E. 06.12.5 4</i>
---	---------	-------------	--

8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Fwd and Aft end for welding

2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033

A/R Aluminum Rod *m/196/12*

3-Do not Grind Flush

P.E. 06.12.5 4

P.E. 06.12.6 4

9.0	QC5/9	WELD INSPECTION
-----	-------	-----------------



Comment: WELD INSPECTION

P. MOG/12/06 (4)

10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06/12/11 (4)

11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
------	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MOG/12/12 (4)

12.0	D2582	Hi-Skid Step Leg Ass'y
------	-------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2582	Step Leg Assy	<i>B28791</i>
---	-------	---------------	---------------

MOG/12/12 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/2/2006 11:11:43 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY

Job Number: 28760

Part Number: D350591122

Job Number:



Seq: #:

Machine Or Operation:

Description :

13.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W3 Rivet

M101519

11/06/12/12 (4)

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Rivet Leg Assembly as per Dwg D2351

11/06/12/12 (4)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Jan 12.12 (4)

16.0

D267334

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2673-34 End Plate

B25396

11/06/12/12 (4)

17.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Fwd End Plate per QSI 004 & Dwg D2351

A/R

Aluminum Rod

M19812

2-Grind end plate flush.

11/06/12/12 (4)

18.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

11/06/12/12 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/2/2006 11:11:44 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY

Job Number: 28760

Part Number: D350591122

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

YL

06/12/13 x 84

20.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m. h. / YL 06/12/13 ④

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk per Dwg D2351 and QSI 005 4.4

Batch: M102635

a.m

06/12/14 ④

22.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

YL

06/12/14 XF

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0

D22301

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Packing Kit	Qty	Part Number	Description	Batch
1	D2230-1	Mounting Lug	B28902	✓

25.0

D22303

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Packing Kit	Qty	Part Number	Description	Batch
1	D2230-3	Mounting Lug	B29646	✓

LB 06/12/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/2/2006 11:11:44 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY

Job Number: 28760

Part Number: D350591122

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 2.4000 f(s)

Pick:

Packing KitQty Part Number Description Batch

1 D2856-400 7.20" Abrasion Strip B28258 ✓

27.0

AN337A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

2 AN3-37A Bolt M14478 ✓

28.0

AN413A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

3 AN4-13a Bolt M102630 ✓

29.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

4 AN960JD10 Washer M100743 ✓

30.0

AN960JD416

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

6 AN960JD416 Washer M102339 ✓

31.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

2 MS21042L3 Nut (or -3) M101917 ✓

Boe/12/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2D Date: 06/12/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/2/2006 11:11:44 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY

Job Number: 28760

Part Number: D350591122

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

MS21042L4

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

3 MS21042L4

Nut (or -4)

119185 ✓ 0306/12/14 (4)

33.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

34.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-122

Location:

PPP Rev:

35.0

QC21

FINAL INSRECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 06/12/15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2351	REV. E SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH FLOAT STEP ASSEMBLY	SCALE NTS
A	95.02.15	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	98.12.17	CHANGED TO BEND, D2850 REPLACES D2357 & D2358, INCORP. DEO 9084	
E	05.11.14	UPDATE FINISHING NOTE	

D2351 HIGH FLOAT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY -041	QTY -042
D2351-041	High Float Step Assembly (LH)	X	
D2351-042	High Float Step Assembly (RH)		X
D2244-55.4	STEP EXTRUSION*	1	1
D2582	STEP LEG ASSEMBLY	1	1
D2673-34	STEP END PLATE	1	1
D2850-1	END BRACKET	1	
D2850-2	END BRACKET		1
MS20600AD4W3	RIVETS	16	16

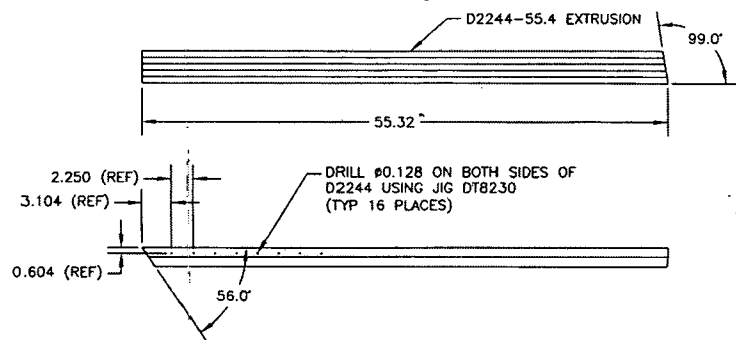
*cut per drawing

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28760

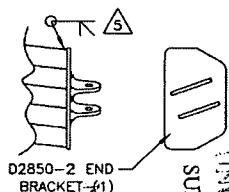
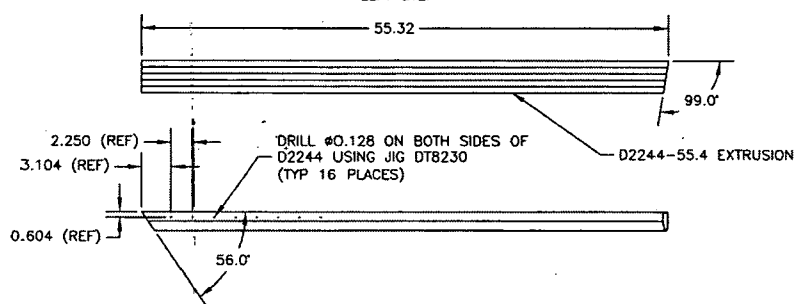
RELEASED
05.11.28 #**Copyright © 1995 by DART AEROSPACE LTD**

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D2351-2 CUTTING/DRILLING DETAIL
RIGHT STEP



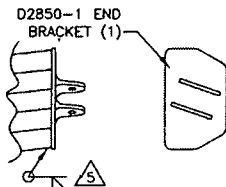
D2351-1 CUTTING/DRILLING DETAIL
LEFT STEP



DETAIL A
SCALE: 1:4

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

ENGINEERING
RETURN TO
SHOP COPY

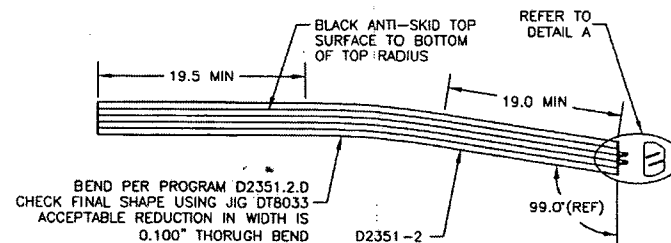


DETAIL B
SCALE: 1:4

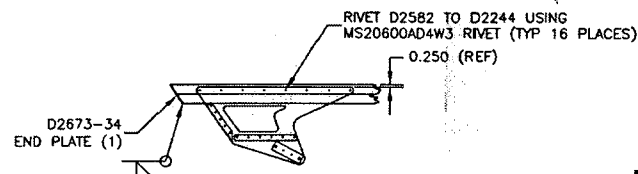
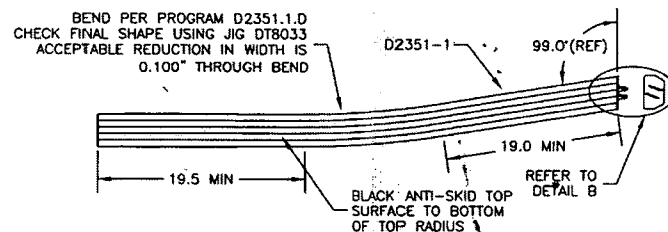
GENERAL NOTES

- 1) WELD PER DART QSI 004
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ⚠ CHAMFER D2244 EXTRUSION 0.075"x45° BEFORE WELDING D2850-1 OR D2850-2 IN PLACE. DO NOT GRIND FLUSH.

D2351-042 BENDING/ASSEMBLY DETAIL
RIGHT STEP



D2351-041 BENDING/ASSEMBLY DETAIL
LEFT STEP



RELEASED
05.11.28

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DESIGN KE	DRAWN BY PH	DART	DART AEROSPACE LTD. HAMMERSBURY, OXFORD, CANADA
CHECKED #	APPROVED #	DRAWING NO. D2351	REV. E SHEET 2 OF 2
DATE 05.11.14		TITLE HIGH FLOAT STEP ASSEMBLY	SCALE 1:12

DART Aerospace Ltd

CUSTOMER RETURN

#R08-020

Initiator: Jean Kerr
 Company: Canadian Helicopters
CCANA01
 Phone No: 450-452-3000

Date: March 11/08
 Invoice # 3743/3786/3778
 Order Entry # 3378/3387/3306

Attach Copy of DHS Return Authorization # 377

Reason for return: PAROS-010 Customer received older revision
AND requires newer rev.

Receiving:

Date Received: 8/3/13 Freight Company: FRODOX Prepaid ☐ Collect ☐

#	Part #	Batch #	Description	Distribute to QC	
1	D350-591-122	B28760	Hel Access SHP	Advise QA	Date:
				<u>OK</u>	<u>8/3/14</u>

Condition of packaging: Good Photograph required: yes ☐ no ☒

Paperwork attached: P/S ☒ Invoice ☐ ARC ☐ Docs ☐ Other ☐

QC:

Quarantine: Location: _____ Condition of Part: installed

Inspect: Initial: [Signature]

#	Part #	Batch #	QC Comments	QC Approval		Scrap
				Initial	W/O #	
1	D350-591-122	B28760	Touch-up & re-stock in S per w/o. New kit required.	<u>[Signature]</u>	<u>38116</u>	

QA Coordinator:

Advise GM as to findings: Initial: _____ Date: _____

Comments:

Issue credit: yes ☐ no ☐

GM Approval: _____ Date: _____

Invoice Amount: _____
 Less Replacement: _____
 Restock Fee: _____
 Freight: _____
 Net Credit: _____
 DHS ☐ Customer ☐

QA: Enter into Q-Pulse with reason for return & File original. Signed: _____ Date: _____

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit